

Split
Work Order ID 71352-1

Tuesday, June 28, 2011 1:51:00 PM

Page 1

Item ID: D3401-041

Revision ID:

Item Name: Tow Cap Assembly

Start Date: 6/28/2011 Start Qty: 8.00

Required Date: 7/13/2011 Req'd Qty: 8.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan: MF

Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3401

Rev B

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks 4.20" Long

0.00

0.00

RF 11.6.30

8

110



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

Turn as per Folio FA532 & Dwg D3401

Folio Rev: _____

Deburr

Dwg Rev: _____

0.00

0.00

RF 11.6.30

8

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

RF 11.6.30

8

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Revision ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: AA

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

OK 11/06/30

8

0

135



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

OK 11/06/30

8

0

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 11/06/30

8

0

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Small Fab

0.00

Memo

0.00

Drill and c'sink using DT8782 as per Dwg D3401

SB 11/07/06

7

EP 11/07/06

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/07/06

7

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

7 BR 11-7-6

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45
320 OF
11:15

7x 0 M-L 11/07/07

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

7 0 11/07/07

195



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

7 0 11/07/07

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: FP-2

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

47

7 of 8 11/07/07

11/7/12

MF 11-07-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, June 28, 2011 1:50:54 PM

Page 1

Work Order ID: 71352

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly



Start Date: 6/28/2011

Required Date: 7/13/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 05.09.01 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500		Purchased	No			200	f	11.5300	0.35	2.947368			
6061 RD bar 3.50													

Location Loc Qty Loc Code

MAT005 5.86

116808 5.86

MAT036 5.67

110993 5.67

NAS1330C3KB116

Purchased

No

100

Each

710.0000

4



Insert

Location Loc Qty Loc Code

ST276 710

102606 200

103185 68

103337 442



29 11.6.30

2.833



32
1107/07

832

W/O:		WORK ORDER CHANGES					
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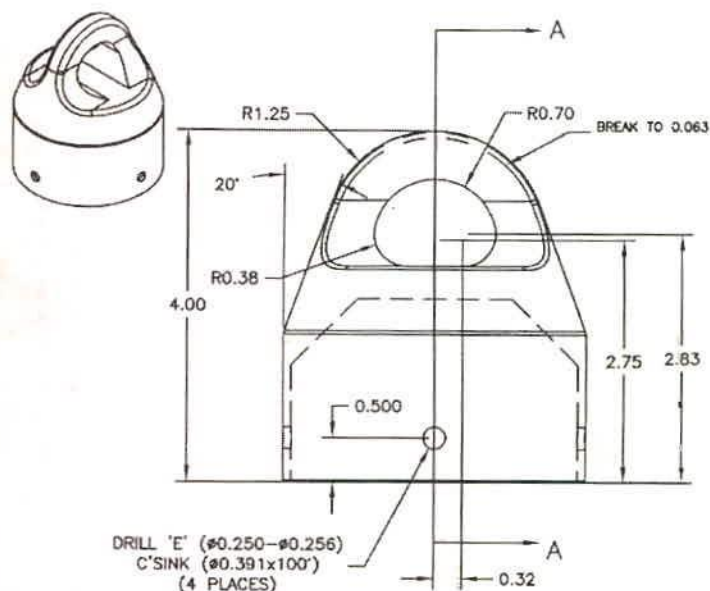
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

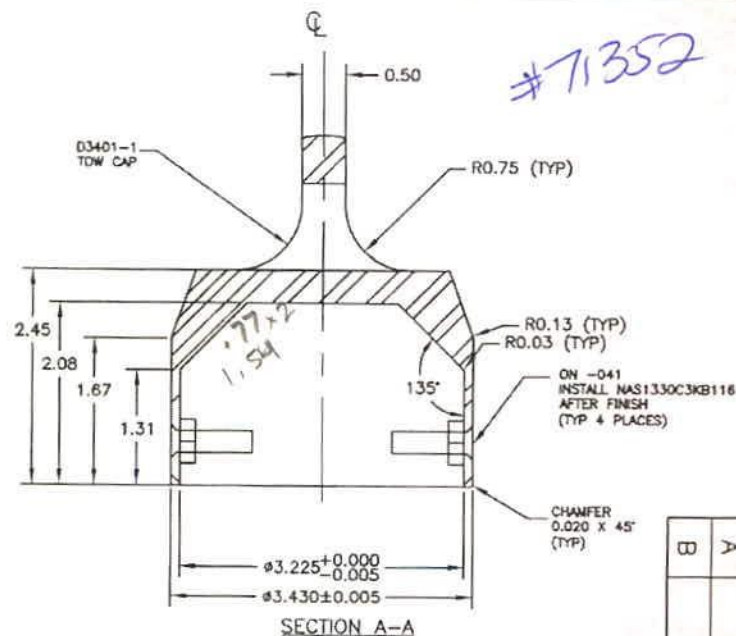
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DART



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 $\phi 3.500$ ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3401
DATE 05.06.09	05.02.24	TOW CAP
	05.06.09	CHAMFER INSIDE, REMOVE RADIUS
		NEW ISSUE
		SCALE 1:2
		SHEET 1 OF 1
		REV. B

RELEASED
05-08-09

#71352

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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